

# Work Order ID 86121

Wednesday, June 20, 2012 3:48:20 PM

\*86121\*

Ship July 13<sup>th</sup> Page 1

Item ID: D3172-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Basket Base Assembly

Stop

\*NS2\*

Start Date: 6/21/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: *ME*

Date: 12-06-20 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3172	Rev C								
100		0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3 as per Dwg D3172 4-Deburr & Remove all markings from material 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 6- Use DT 8996 jig to locate D3174-1 as per dwg 7- Deburr								
110	QC9- Inspect visual per: QS1004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

(1x)

*12-10-23*

SAD 12-10-17

(1x)

12-10-22

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86121****\*86121\***

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Wednesday, June 20, 2012 3:48:20 PM

Item ID: D3172-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Basket Base Assembly

Stop **\*NS2\***Start Date: 6/21/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

1 16 12-1024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 86121

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Wednesday, June 20, 2012 3:48:20 PM

Item ID: D3172-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Basket Base Assembly  
 Start Date: 6/21/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/13/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*130\***

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME: 9:30

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:00

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*1X*

*12/10/24*

*W1 22878*

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Quality Control

Memo

0.00

*1 \$ 12-10-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*86121\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Start Date:** 6/21/2012      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 7/13/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**                      **Process Plan:**

Date:

**Tooling:**

Date:

Run Start \*NR1\*

**OC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

[illegible]

150

Identify as per dwg & Stock Location: D/30-701-0003

**\*150\***

### Packaging

## Memo

0.00

## Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

12/10/29dj

12-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 86121

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 6/21/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B04.01.05Added Step 5 inspectionKJ/RF  
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC  
pressure wash DD VERF:EC IPP Rev:D 11.04.04 added

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	35.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		35							
				55729		4							
				69890		31							
D2232-3 Basket Hinge		Manufactured	No			100	Each	11.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		9							
				82304		9							
				WA005		2							
				75581		2							
D2327-3 Spacer Bushing		Manufactured	No			100	Each	30.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		26							
				82325		26							
				WA005		4							
				75564		1							
				77229		1							
				81144		2							

B 69890 → 2x 12-10-17

B 86914 → 2x 12-10-17

B 88561 → 2x 12-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 2

Work Order ID: 86121

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 6/21/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 81.0000  
Mounting Bracket

<sup>2</sup> ~~B88574~~ → 2x ~~SYA-10.17~~

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	49	
82506	2	
83230	3	
85436	20	
85452	24	
WA005	32	
70766	2	
81253	1	
82897	29	

D3166-1 Manufactured No 100 Each 20.0000  
Basket Hoop

<sup>4</sup> ~~B87920~~ → 2x ~~SYA-12.10.17~~  
~~B87426~~ → 2x

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	20	
84712	20	

D3174-1 Manufactured No 100 Each 6.0000  
Mounting Lug

<sup>8</sup> ~~B871272~~ → ~~8x~~ ~~SYA-12.10.17~~  
~~B86122~~ → 1x

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA005	6	
71272	6	

M304EX0.75-16F Purchased No 100 sf 870.6152  
Expanded Metal Flat SS

<sup>48</sup> <sup>48</sup> ~~11.122604~~ → 48  
~~SYA-12.10.23~~

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4.9094	
121738	4.9094	
WA035	865.7057637	
117197	102.9036	
120917	101.57273	
121521	0.00013372	
121849	21.2293	
122080	320	
122138	320	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Start Date: 6/21/2012

Required Date: 7/13/2012

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100 f

1,384.9169

51

53.684211

304 SQ Tube .75x.75x.065W

*SAI 12/10-17*

Location

Loc Qty

Loc Code

MAT

1000

112398

0

122051

1000

MAT017

343.9169370

120267

26.9468670

120633

316.97007

MAT018

41

7636

41

*M123303*

*536843*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

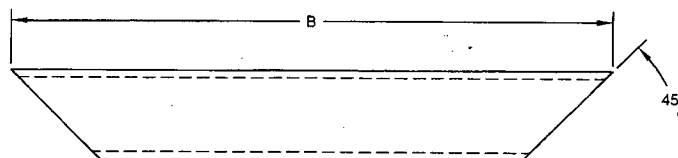
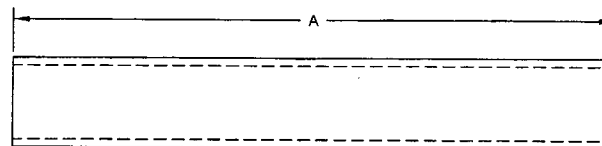
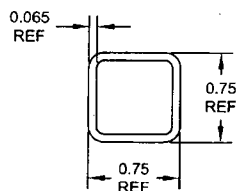
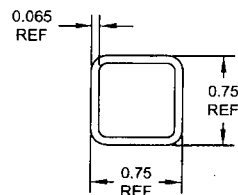
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



#8601

RELEASED  
08-15-21/17



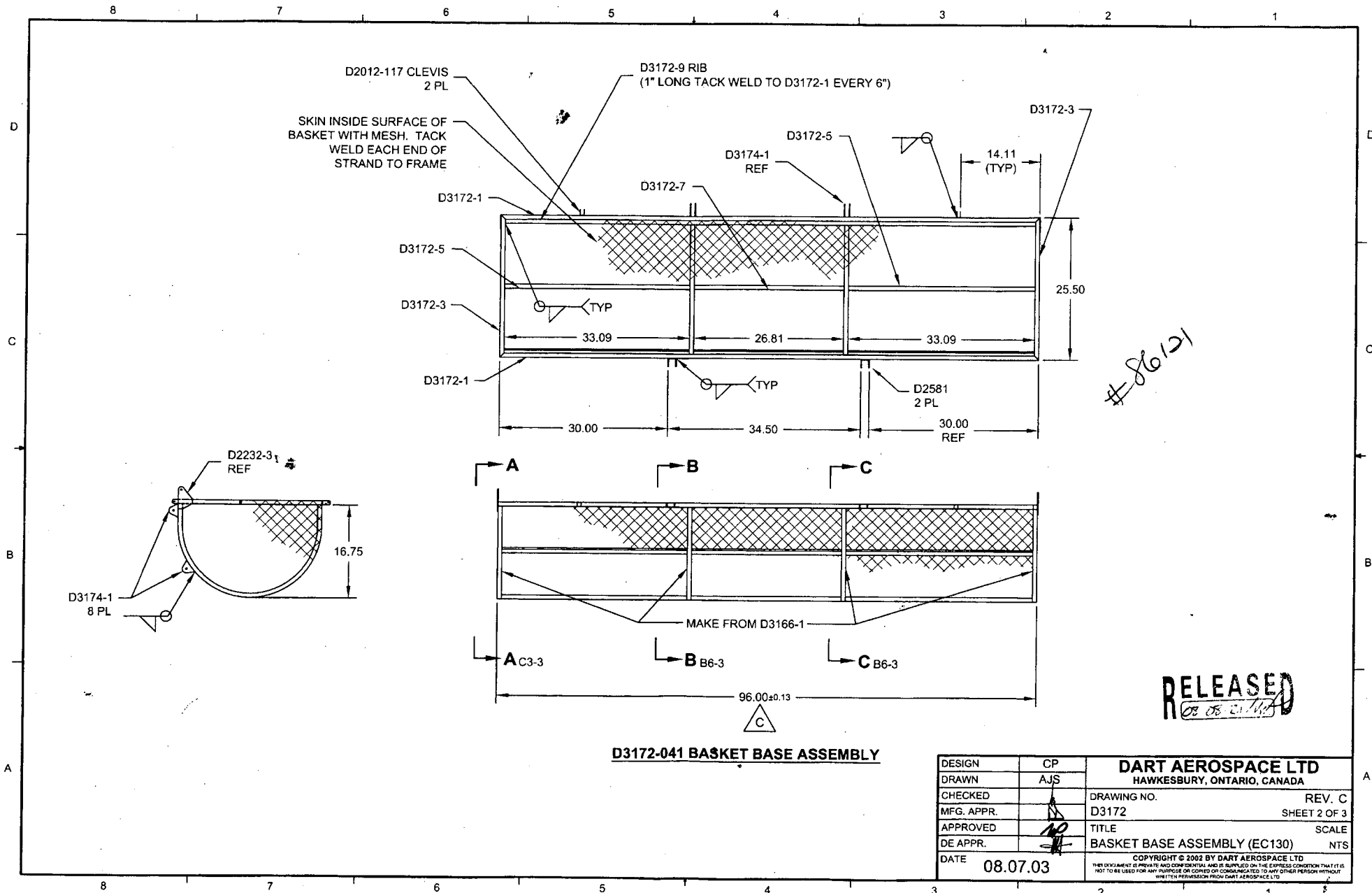
## NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF: DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF: DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

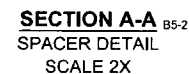
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	















#86121

RELEASE  
08-08-21

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

